

Work Order ID 52767

October 14, 2009 9:21:51 AM



Page 1

Item ID: D3953-11

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Spacer

Start Date: 14/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date:

21-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

A

100



Hardinge

Hardinge CNC Lathe Small

0.00

0.00

5 NOV 14 15

40 *✓*

Memo

TURN AS PER FOLIO FA856 & DWG

FOLIO REV: *NA*

DWG REV: *A*

DEBURR

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

5 NOV 10 15

40 *✓*

Memo

Work Order ID 52767

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Page 2

Item ID: D3953-11

Accept



Setup Start



Revision ID: A

Item Name: Gas Spring Spacer

Stop



Start Date: 14/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MF 09.10.15

(40)

Quality Control

130

Identify as per dwg & Stock Location: 139C

0.00



Packaging

Memo

0.00

9/10/16 400 SP

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/10/19 JF

Quality Control

ME 09-10-19

Picklist Print

October 14, 2009 9:21:58 AM

Page 1

Work Order ID: 52767

Parent Item: D3953-11

Parent Item Name: Gas Spring Spacer

Comments:

Start Date: 14/10/2009

Required Date: 21/10/2009

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MDELNRINR0.750

Purchased

No

100

f

95.0275

2.5263



Delrin Round Bar 0.75"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

95.0275

109183

1.84

110962

12.26

112418

65.0275

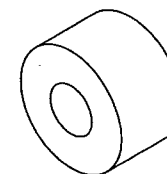
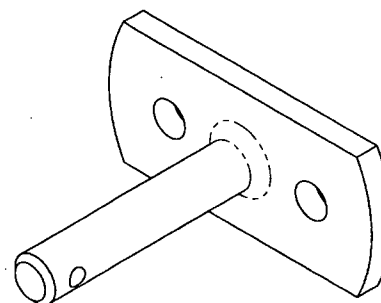
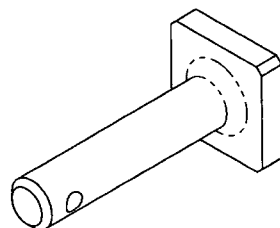
112480

15.9

2.53 ft 21 09/10/15

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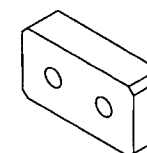
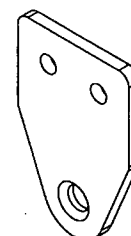
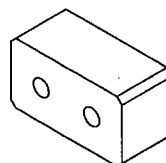
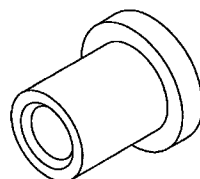
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)

D3953-17 GAS SPRING SPACER
(SPLIT LID)

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2009-10-08

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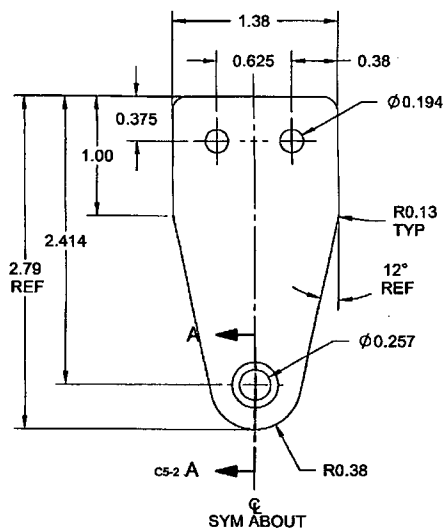
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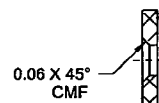
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NO. 52767

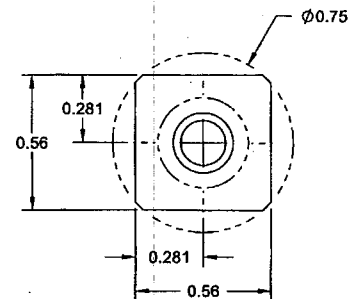
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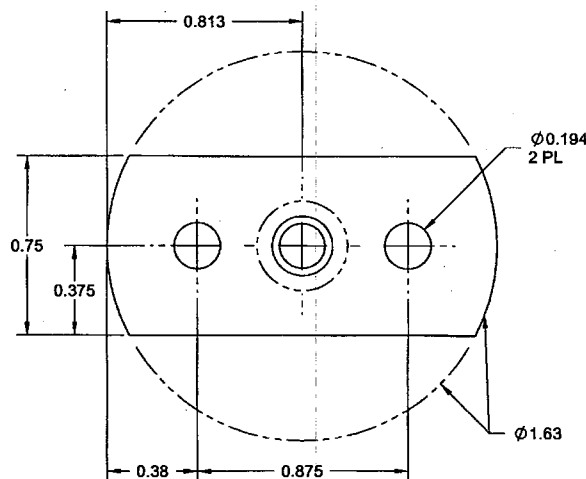
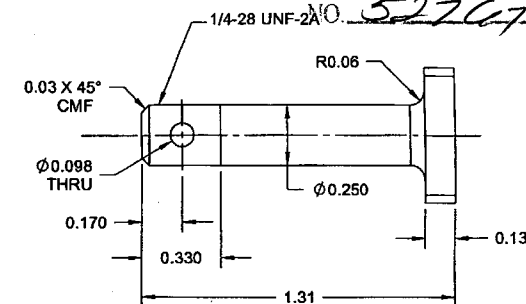
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(FULL LID)



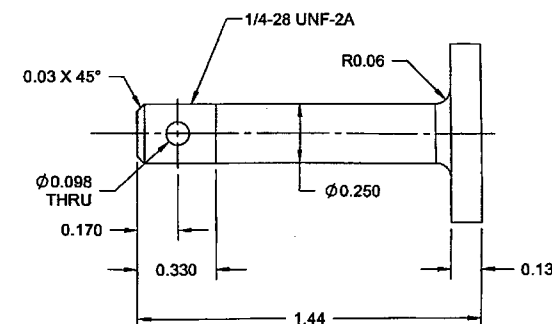
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED





5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

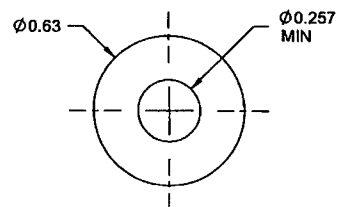
7) WEIGHT -1: 0.11 lbs

-3: 0.03 lbs

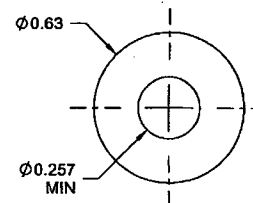
-5: 0.06 lbs

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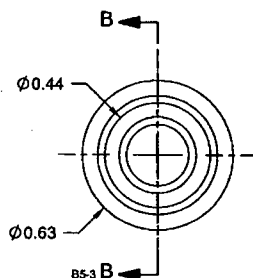
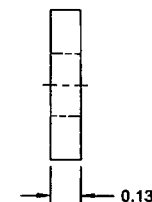
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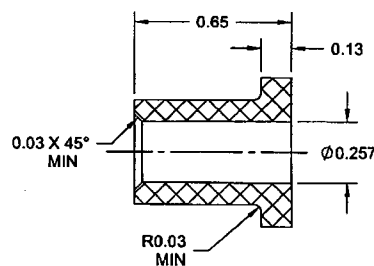
D3953-7 GAS SPRING SPACER



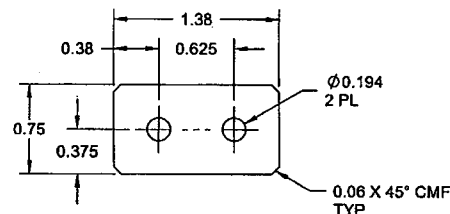
D3953-9 GAS SPRING WASHER



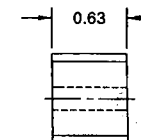
D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER



NOTES:

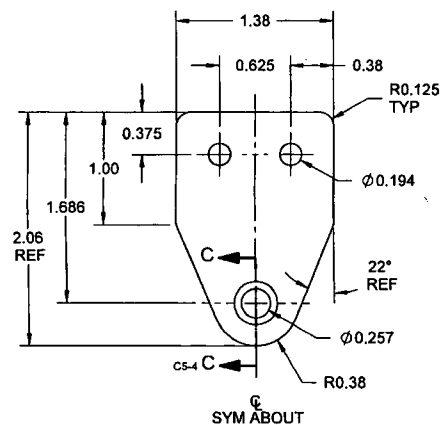
- 1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R
- 13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

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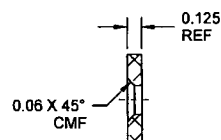
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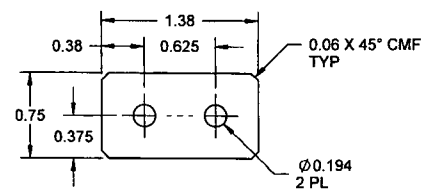
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D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)

NOTES:

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
 -17: 0.10 lbs

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